

# Work Order ID 84133

May-03-12 2:33:03 PM

**\*84133\***

Page 1

Item ID: D2230-3

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Lug

Start Date: 03/05/2012 Start Qty: 200.00

**\*200\***

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 200.00

**\*200\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/03

Tooling:

Date:

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00

**\*100\***

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch: \_\_\_\_\_

CL 12/05/07

Cut @ meter

110

0.00

**\*110\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1 perch

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA927

FOLIO REV: \_\_\_\_\_

DWG REV: \_\_\_\_\_

Check for crack while loading into the machine.

2- deburr

issue P/O to meter  
machine as perching D 2230 REV. G  
PO 16897  
12-05-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84133

\*84133\*

Page 2

May-03-12 2:33:03 PM

Item ID: D2230-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Lug

Start Date: 03/05/2012 Start Qty: 200.00

\*200\*

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 200.00

\*200\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 *used*  
QC2-Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC Memo

0.00

Quality Control

*used + inspect for transit damage  
attached c/c to W/O*

*10/12/12 (200)*

130 QC Inspect parts - second check

0.00

\*130\*

QC Memo

0.00

Quality Control

*200*

*11/12/05-31*

150 Chemical Conversion Coat per QSI005 4.1

0.00

\*150\*

HandFinish Memo

0.00

Hand Finishing

*200*

*NG 125-5*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Work Order ID 84133

**\*84133\***

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May-03-12 2:33:03 PM

Item ID: D2230-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Lug

Stop **\*NS2\***

Start Date: 03/05/2012 Start Qty: 200.00

**\*200\***

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 200.00

**\*200\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

200  $\phi$  12-6-7

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*170\***

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

9:30  
320°F  
10:00

200x  $\phi$  M/K 12/06/07

180

QC3- Inspect Part Finish

0.00

**\*180\***

QC

Memo

0.00

Quality Control

200x  
COUNTED  $\phi$  M/K 12/06/07

M121134

W/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 84133

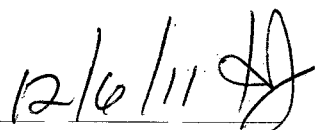
May-03-12 2:33:03 PM

**\*84133\***

Page 4

Item ID: D2230-3      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Lug  
Start Date: 03/05/2012      Start Qty: 200.00      **\*200\***      Cust Item ID:  
Required Date: 10/05/2012      Req'd Qty: 200.00      **\*200\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>51480</u>  Memo	0.00  0.00				<u>200</u>		<u>545 12/06/08</u>	
200 <b>*200*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00						<u>12/6/11</u> 	

*mf*  
12-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

May-03-12 2:33:06 PM

Page 1

Work Order ID: 84133

**\*84133\***

Parent Item: D2230-3

**\*D2230-3\***

Parent Item Name: Lug

Start Date: 03/05/2012

Required Date: 10/05/2012

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP D00.05.18Added inspection level 8, and removed P/O for powder  
coatEC IPP REV :E NEW FOLIO # 10-05-  
25 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P		Purchased	No				Each	0.0000		200			
<b>*D2230-3P*</b>									**				
LUG													
D2423		Manufactured	No			100	f	539.3680	0.0683	14.37895			
<b>*D2423*</b>									**				
Lug Extrusion													

*1440/31 200*

*0212/05/07*

Location

Loc Qty

Loc Code

MAT006

539.368

43722

161.5

68331

73.868

81557

304

*14.38*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

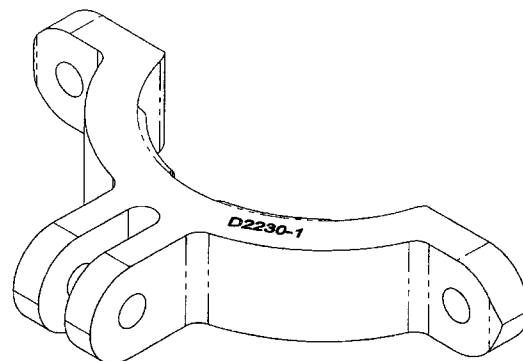
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

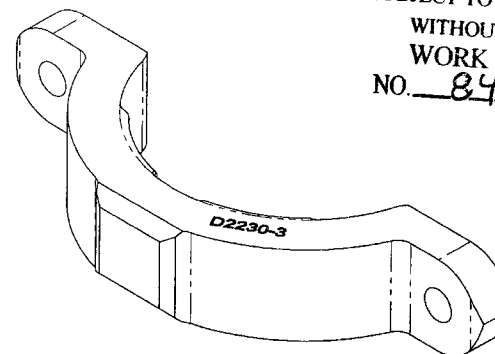
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SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 84133 MLJ  
 12/05/03



**D2230-1 MOUNTING LUG**



**D2230-3 MOUNTING LUG**

**RELEASED**  
 01/06/2004



**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs  
 -3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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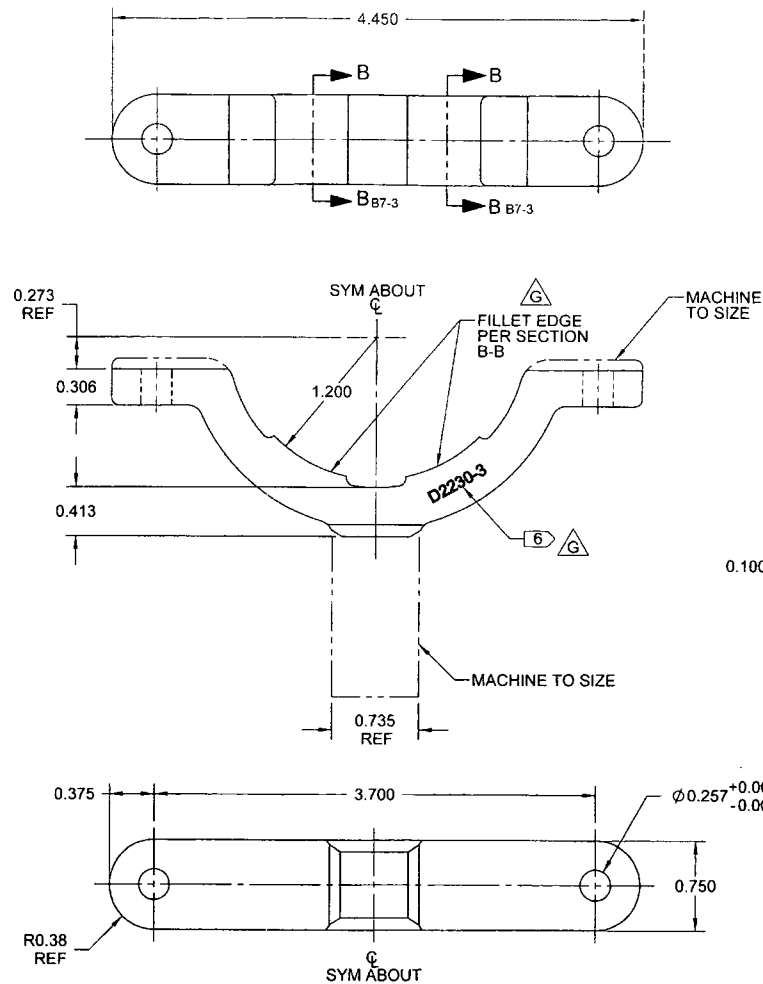
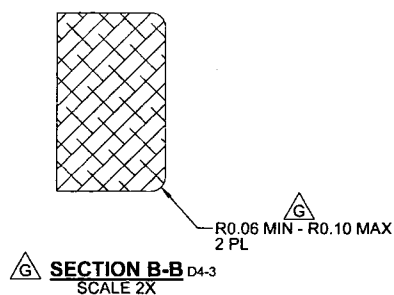
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

84133



RELEASED  
09/06/25

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	A/S		
CHECKED		DRAWING NO. <b>D2230</b>	REV. G SHEET 3 OF 3
MFG. APPR.		TITLE <b>MOUNTING LUG</b>	SCALE NTS
APPROVED		<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.			
DATE	09.01.16		

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0, Canada  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 18700  
**Date:** May 29, 2012  
**Page:** 1

<b>Sold to:</b>  <b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 16897	<b>Sold By:</b> Dewar, Eric
<b>Shipped By:</b> your truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug	Each	200	200	
D2230-3 Mounting Lug	Each	200		200
D2230-1 Mounting Lug	Each	200		200
D2230-1 Mounting Lug	Each	200		200
as per DWG: D2230 REV:G				
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0  
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-3	Lug	16897

MATERIAL: supplied by DART B81577

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, May 29, 2012